



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

5045503 15"
D4171-1
Job Sheet 169892

Part No: D4171-1

Job Qty: 12 ea

Part Name: Bushing



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/3/18

Job Tracking No:

Due Date: 1/12/18

Created By: Mario Poulin

Type: Stock

Description:

Note: DWG REV A IPP REV:A NEW ISSUE 10-09-22 JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	12 Ea	1/11/18	1/11/18	0.00	0.00	Start Up Machining-2		<i>MIP 18/02/14</i>
100	Doosan	12 pcs	1/12/18	1/12/18	0.00	2.40	Doosan		<i>MIP 18/02/14</i>
140	QC	12 pcs	1/12/18	1/12/18	0.00	0.00	QC8		<i>MIP 18/02/14</i>
200	Packaging	12 pcs	1/12/18	1/12/18	0.00	0.00	Packaging3-2		<i>ST083 FEB 21 2018</i>
210	QC21-SA	12 Ea	1/12/18	1/12/18	0.00	0.00	QC21		<i>DAS 21 9-00 FEB 21 2018</i>

Part Op
Descriptions: 100 - 1-Turn as per Dwg & Folio FA963

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M303R1.000	1	18	0	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Bushing	0.750Inches ± 0.010	0.751 0.740		
2	Bushing	0.540Inches ± 0.010	0.542 0.530		
3	Bushing	0.210Inches ± 0.010	0.210 0.200		
4	Bushing	0.150Inches ± 0.010	0.150 0.140		
5	Bushing	0.305Inches + 0.000 - 0.002	0.304 0.305 0.303	Diameter	
6	Bushing	0.010Inches ± 0.010	0.010 0.020 0.000	Radius	
7	Bushing	0.060Inches ± 0.010	0.060 0.070 0.050		
8	Bushing	0.395Inches + 0.015 - 0.005	0.395 0.410 0.390		
9	Bushing	0.563Inches + 0.002 - 0.015	0.560 0.565 0.548		
10	Bushing	0.880Inches ± 0.030	0.880 0.910 0.850	Diameter	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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12	Bushing	0.063Inches ± 0.010	0.063	0.073 0.053	Radius
13	Bushing	0.060Inches ± 0.010	60°	0.070 0.050	Radius
14	Bushing	45.000Degrees ± 0.500	45°	45.500 44.500	Angle
15	Bushing	0.023Inches + 0.030 - 0.010	0.023	0.053 0.013	
16	Bushing	0.030Inches ± 0.010	0.030	0.040 0.020	
17	Bushing	20.000Degrees ± 0.500	20°	20.500 19.500	Angle

Plex 1/3/18 8:44 AM dart.poulin.mario

DQA: _____ Date: _____

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Dart Aerospace Ltd. 1270 Aberdeen Street Hawthorn, ON K6A 1K7 CANADA TEL: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com DART AEROSPACE Container No: S043504 Part: D4171-1 Job No: 169892 Serial No/Batch: S043504 Revision: D4171 Inspector: Date: 02/10/18		FAULT CATEGORY <table style="width:100%; border: none;"> <tr> <td style="border: none;">☐ Pressure/Forced</td> <td style="border: none;">☐ Temperature/Cure</td> <td style="border: none;">☐ Power Loss/Surge</td> <td style="border: none;">☐ Positioned Wrong</td> </tr> <tr> <td style="border: none;">☐ Bending</td> <td style="border: none;">☐ Set-up</td> <td style="border: none;">☐ Folio/Program</td> <td style="border: none;">☐ Outside Dimensions</td> </tr> <tr> <td style="border: none;">☐ Centre Not Concentric</td> <td style="border: none;">☐ BOM/Route</td> <td style="border: none;">☐ Grain</td> <td style="border: none;">☐ Over/Under tolerance</td> </tr> <tr> <td style="border: none;">☐ Cracks</td> <td style="border: none;">☐ Broken/Damage/Defect</td> <td style="border: none;">☐ Weld</td> <td style="border: none;">☐ Part Incorrect</td> </tr> <tr> <td style="border: none;">☐ Crimp/Kink/Ripple/Wave</td> <td style="border: none;">☐ Inspection Incomplete/Unqualified</td> <td style="border: none;">☐ Wrong Stock Pulled</td> <td style="border: none;">☐ Part Lost/Missing</td> </tr> <tr> <td style="border: none;">☐ Cuffs</td> <td style="border: none;">☐ Contamination</td> <td style="border: none;">☐ Out of Sequence</td> <td style="border: none;">☐ Part Moved</td> </tr> <tr> <td style="border: none;">☐ Crushing</td> <td style="border: none;">☐ Countersink</td> <td style="border: none;">☐ Off-set</td> <td style="border: none;">☐ Drawing</td> </tr> <tr> <td style="border: none;">☐ Heat Treat</td> <td style="border: none;">☐ Cut Too Short</td> <td style="border: none;">☐ Mislabeled</td> <td style="border: none;">☐ Finish</td> </tr> <tr> <td style="border: none;">☐ Wave/Twist in Tube</td> <td style="border: none;">☐ Instructions Incomplete/Unclear</td> <td style="border: none;">☐ Fit/Function</td> <td style="border: none;">☐ Misread</td> </tr> <tr> <td style="border: none;">☐ Marks/Chatter</td> <td style="border: none;">☐ Drill Holes</td> <td style="border: none;">☐ Misaligned/off center</td> <td style="border: none;">☐ Turning Sequence</td> </tr> </table>				☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence
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